



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2534
Job Sheet 179679



Part No: D2534

Job Qty: 24 ea

Part Name: Lock Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now on Waterjet 06-06-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/07
100	Waterjet	24 pcs	7/18/18	7/18/18	0.00	1.00	Waterjet1		SC 18/07/07
110	QC	24 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Waterjet-4		SC 18/07/07
120	QC	24 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	Packaging	24 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3		38
140	QC21-SA	24 Ea	7/18/18	7/18/18	0.00	0.00	QC21		DAS 21 9-00 JUL 11 2018

Part Op 100 - 1-Cut as per Dwg D2534

Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.0248 sf (.0427 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	1	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Plate	0.447inches + 0.006 - 0.001	0.453 0.446	0,448	
2	Lock Plate	0.500inches ± 0.010	0.510 0.490	0,503	
3	Lock Plate	0.173inches ± 0.010	0.183 0.163	0,175	
4	Lock Plate	0.096inches ± 0.010	0.106 0.086	0,099	
5	Lock Plate	0.125inches ± 0.010	0.135 0.115	0,127	
7	Lock Plate	0.200inches ± 0.010	0.210 0.190	0,202	
8	Lock Plate	0.125inches ± 0.010	0.135 0.115	0,115	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																																																	
Description Work Order Deviation DART AEROSPACE Container No: S089971 Part: D2534 Job No: 179679 Serial No/Batch: S089971 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/09/18																																																																																																					
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">Environment</td> <td>☐</td> <td style="width: 30%;">No Re-verification</td> <td>☐</td> <td style="width: 30%;">Pressure,</td> <td>☐</td> <td style="width: 30%;">tioned Wrong</td> <td>☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>ide Dimensions</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Nc</td> <td>☐</td> <td>/Under tolerance</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Part Incorrect</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kini</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td>☐</td> <td></td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td>☐</td> <td></td> <td>☐</td> </tr> </table> Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐						Environment	☐	No Re-verification	☐	Pressure,	☐	tioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	ide Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Nc	☐	/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kini	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐		☐		☐	Misidentified	☐	Past Due	☐	OTHER :	☐		☐
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